

Date: Wednesday, 30/07/2008 5:29:17 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y LH		
Job Number	: 40820			Part Number	: D412769043		
Estimate Number	: 13306			Drawing Number	: D412-769-1 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 15/08/2008		
Previous Run	: 40000			Qty:	1 Um: Each		
Written By	:						
Checked & Approved By	: <u>JUL 08-7-31</u>						
Comment	: Est rev A 08-05-12 new issue DD verified by:EC Est Rev:B 08-07-17 revB as per dwg DD verified by:ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D3782045	Back Leg Assembly	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: <u>B40873</u>	
3.0	D3782041	Front Inboard Leg Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: <u>B40870</u>	
4.0	D3782043	Front Outboard Leg Assembly, LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, LH batch: <u>B40871</u>	
5.0	D3783041	Lateral Brace Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: <u>B40874</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40820

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3783043 Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: B 40875

SB

7.0 D3783045 Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B 40876

SB

8.0 D3784041 Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: B 40877

SB

9.0 D3784043 Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: B 40878

SB

10.0 D3784044 Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: B 40879

SB

11.0 D37661 Front Rail, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: B 40863

SB

12.0 D37663 Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B 40710

SB

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40820

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	D37671	Upper Rail
14.0	D37921	Seat Belt Eye Bolt
15.0	AN415A	Bolt
16.0	AN45 13A	EYE BOLT
17.0	AN510A	Bolt
18.0	AN513A	Bolt
19.0	AN960JD10	Washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Upper Rail
batch: B 40711 SB

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Seat Belt Eye Bolt
batch: B 40209 SB

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M 108 077 SB

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
EYE BOLT
batch: M 107 938 SB

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
batch: M 108 471 SB

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M 108 167 SB

Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)
Washer
batch: M 108 588 (or NAS1149D0363J) batch: SB 08/08/20 D

W/O:		WORK ORDER CHANGES				
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Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40820

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD416	Washer
	<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Washer</p> <p>batch: <u>M 108161</u></p> <p>(or NAS1149D0463J) batch:</p>	
21.0	AN960JD516	Washer
	<p>Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)</p> <p>Washer</p> <p>batch: <u>M 108266</u></p> <p>(or NAS1149D0568J) batch:</p>	
22.0	AN52510R24	Screw
	<p>Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)</p> <p>Screw</p> <p>batch: <u>M 108270</u></p>	
23.0	MS21042L3	Nut
	<p>Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)</p> <p>Nut</p> <p>batch: <u>M 108744</u></p>	
24.0	MS21042L4	Nut
	<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Nut</p> <p>batch: <u>M 107499</u></p>	
25.0	MS21042L5	Nut
	<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)</p> <p>Nut</p> <p>batch: <u>M 108471</u></p>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40820

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08-08-21 ①

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:20

OVEN TEMPERATURE: 320°

FINISH TIME: 1:50

FL 08/08/21 ①

29.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-21 ①

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751 Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch: 40658

FF 08/08/22 ①

3.1 A3792-1 Seat belt eyebolt

Qty 3 batch: B40209

SB 08/08/21 ③

10/08/21
(perm. change)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40820

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :	
32.0	D37741	Seat Bottom, LH/RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: <u>B40587</u>	FF 08/08/22 ①
33.0	D37743	Seat Back, LH/RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: <u>B40588</u>	FF 08/08/22 ①
34.0	AN525 10R22	Screw	
		Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Screw batch: <u>M107936</u>	FF 08/08/22 ①
35.0	AN960JD10L	Washer	
		Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Washer batch: <u>105793</u> (or NAS1149D0332J) batch:	FF 08/08/22 ①
36.0	MS21042L3	Nut	
		Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Nut batch: <u>M108747</u>	FF 08/08/22 ①
37.0	AN35A	Bolt	
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: <u>M100108</u>	FF 08/08/22 ①
38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install remaining parts as per dwg D412-769-1	FF 08/08/22 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 40820

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

39.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/22 (1)

40.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 100 -

40808

41.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22 (1)

Job Completion



MF 08-08-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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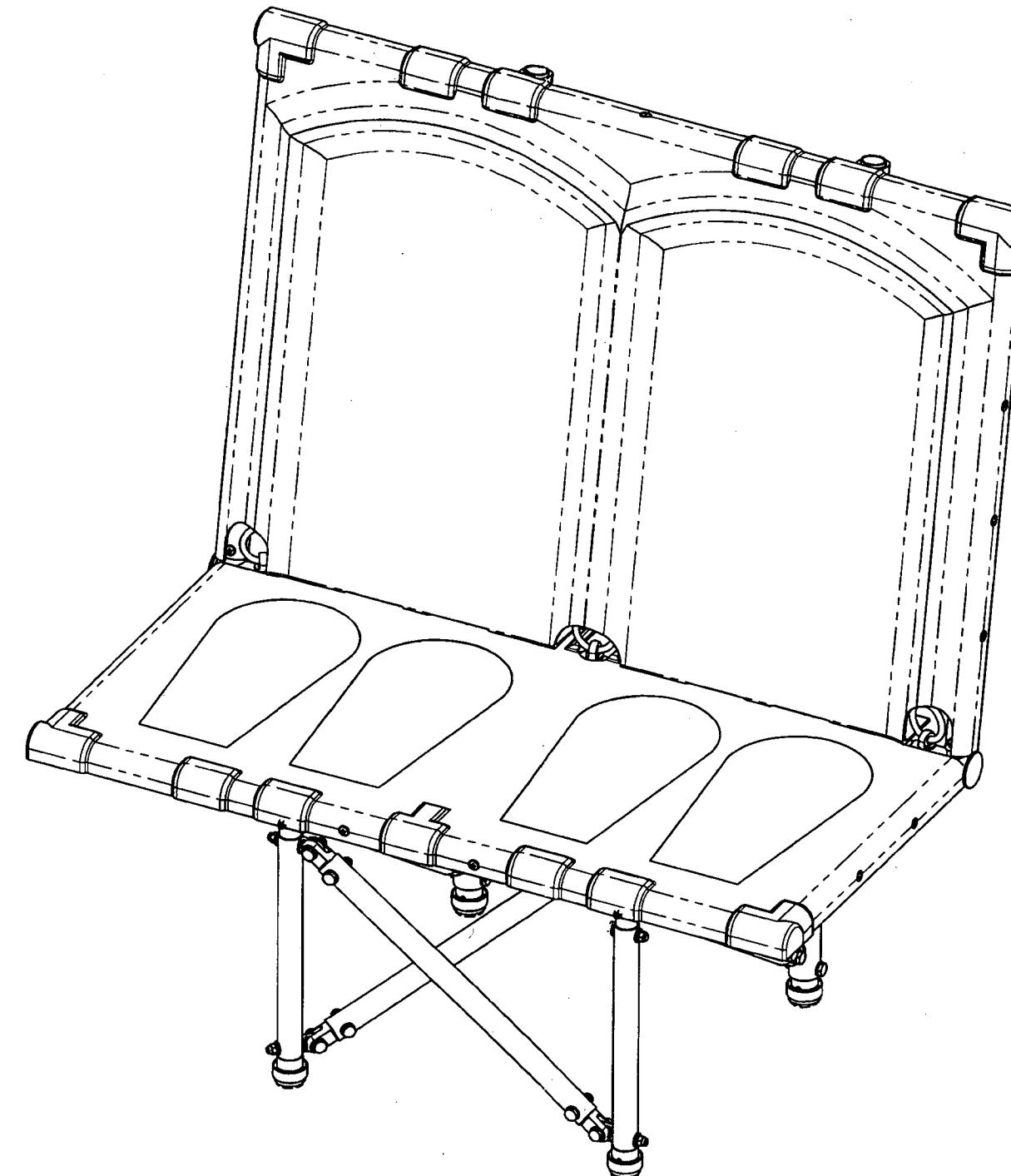
C

B

B

A

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D412-769-043 AFT FACING SEAT ASSY, LH

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PA</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AM</i>	D412-769-1	SHEET 1 OF 7
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>AM</i>	AFT FACING SEAT ASSY, LH	
DATE	08.06.25	NTS	

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WORK ORDER
NO. 40800

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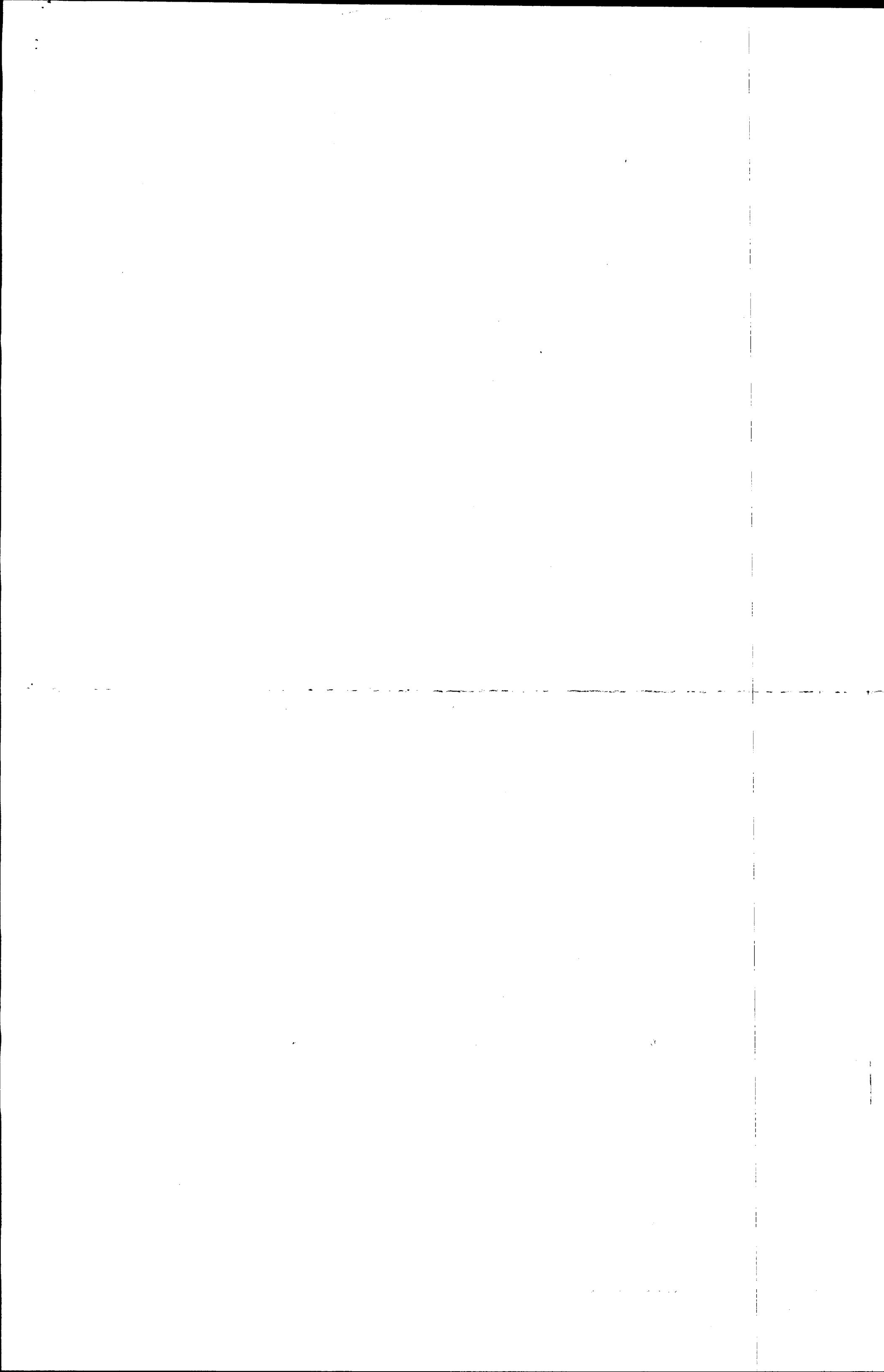
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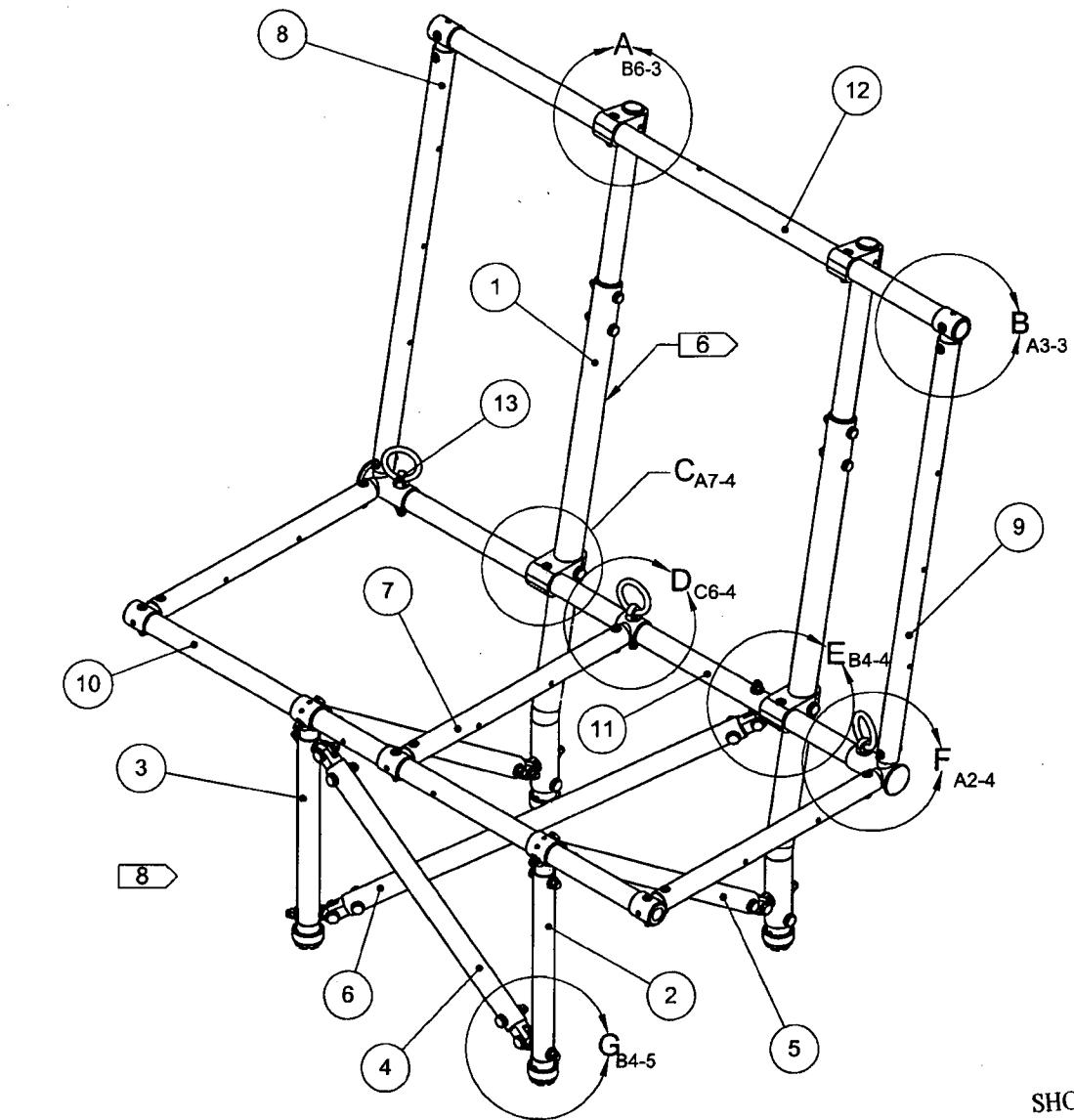
B

B

A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

B
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08.07.09
NO. 6080

NOTES:

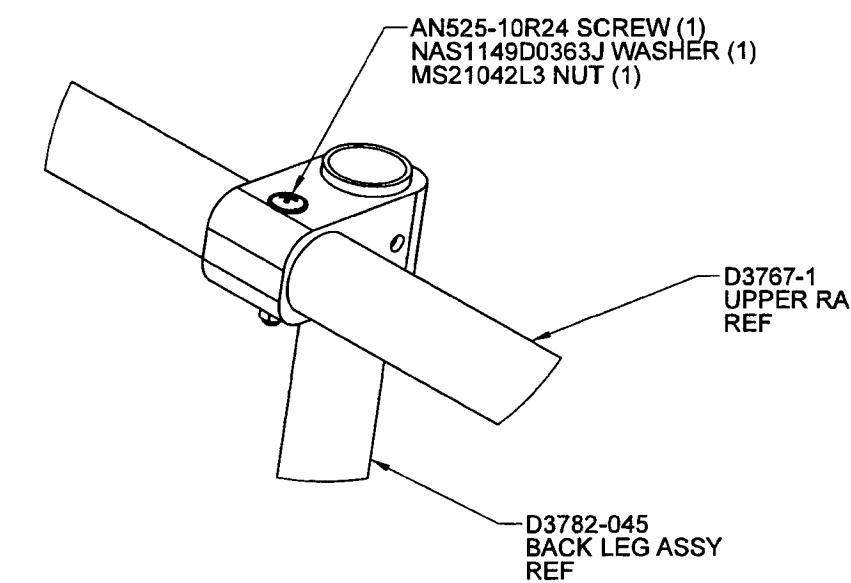
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ed</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>M</i>	D412-769-1	SHEET 2 OF 7
APPROVED	<i>M</i>	TITLE	SCALE
DE APPR.	<i>M</i>	AFT FACING SEAT ASSY, LH	NTS
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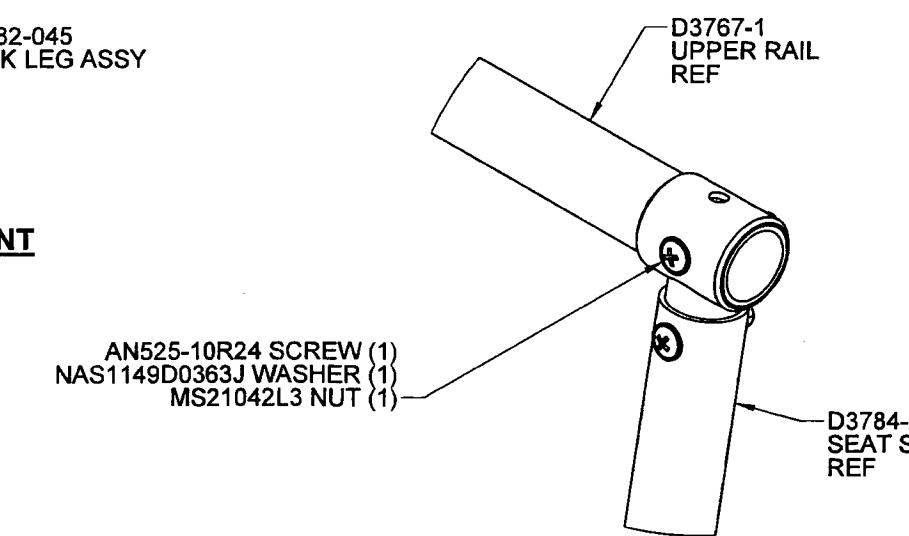
8 7 6 5 4 3 2 1

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DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
5 PL

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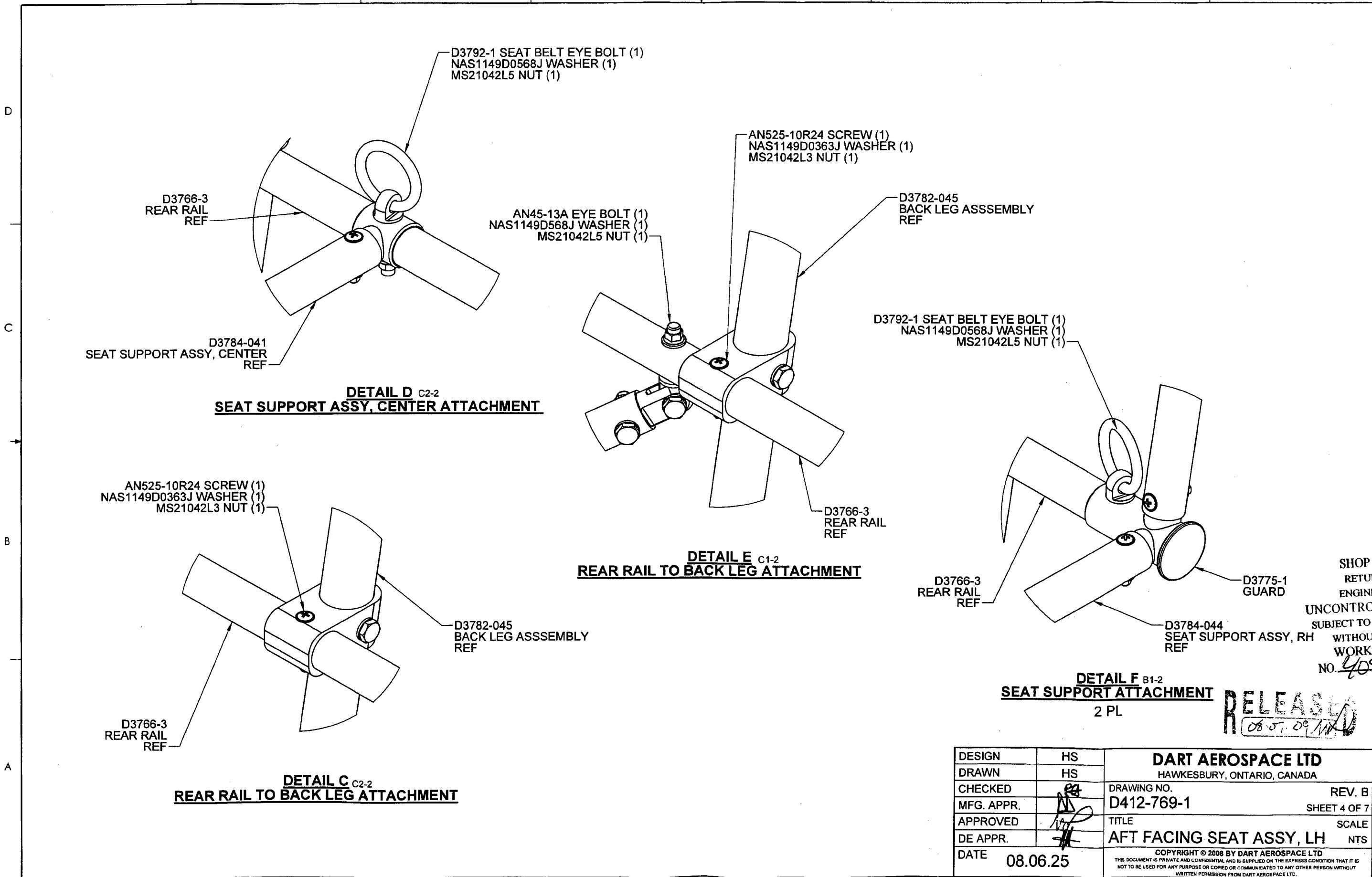
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07.07.09

DESIGN	HS	DART AEROSPACE LTD			
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RE	DRAWING NO.			
MFG. APPR.	MP	D412-769-1	REV. B		
APPROVED	MM	SHEET 3 OF 7			
DE APPR.	MM	TITLE			
DATE	08.06.25	AFT FACING SEAT ASSY, LH			
NTS					
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8 7 6 5 4 3 2 1

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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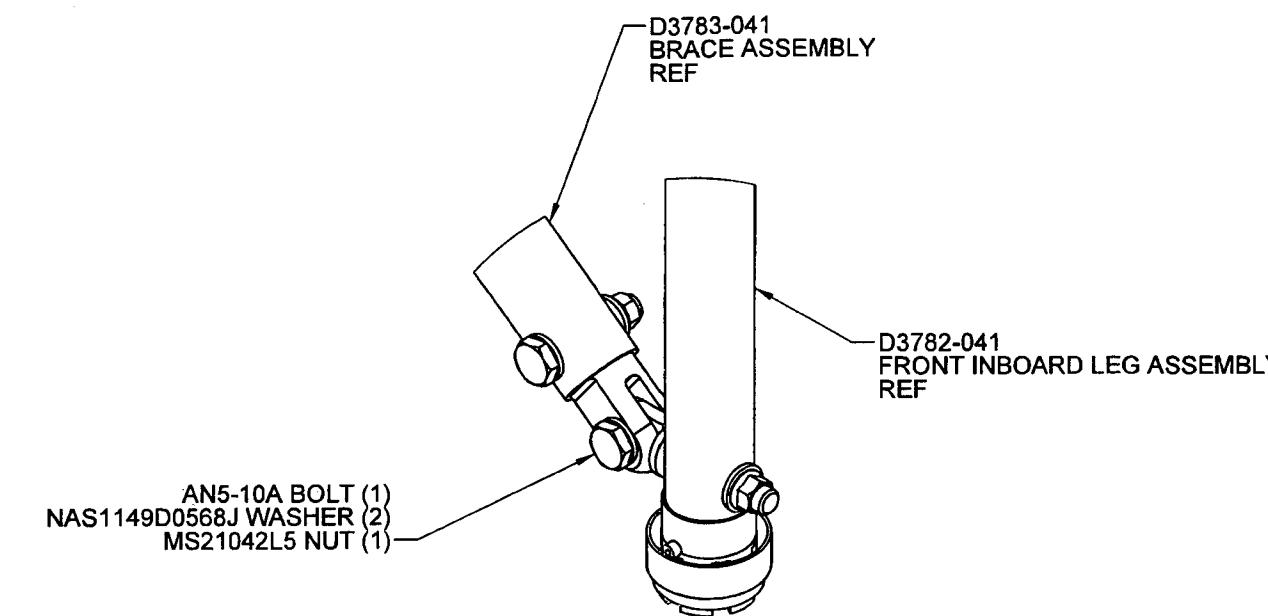
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DETAIL G_{B2-2}
BRACE ATTACHMENT

6 PL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 100820

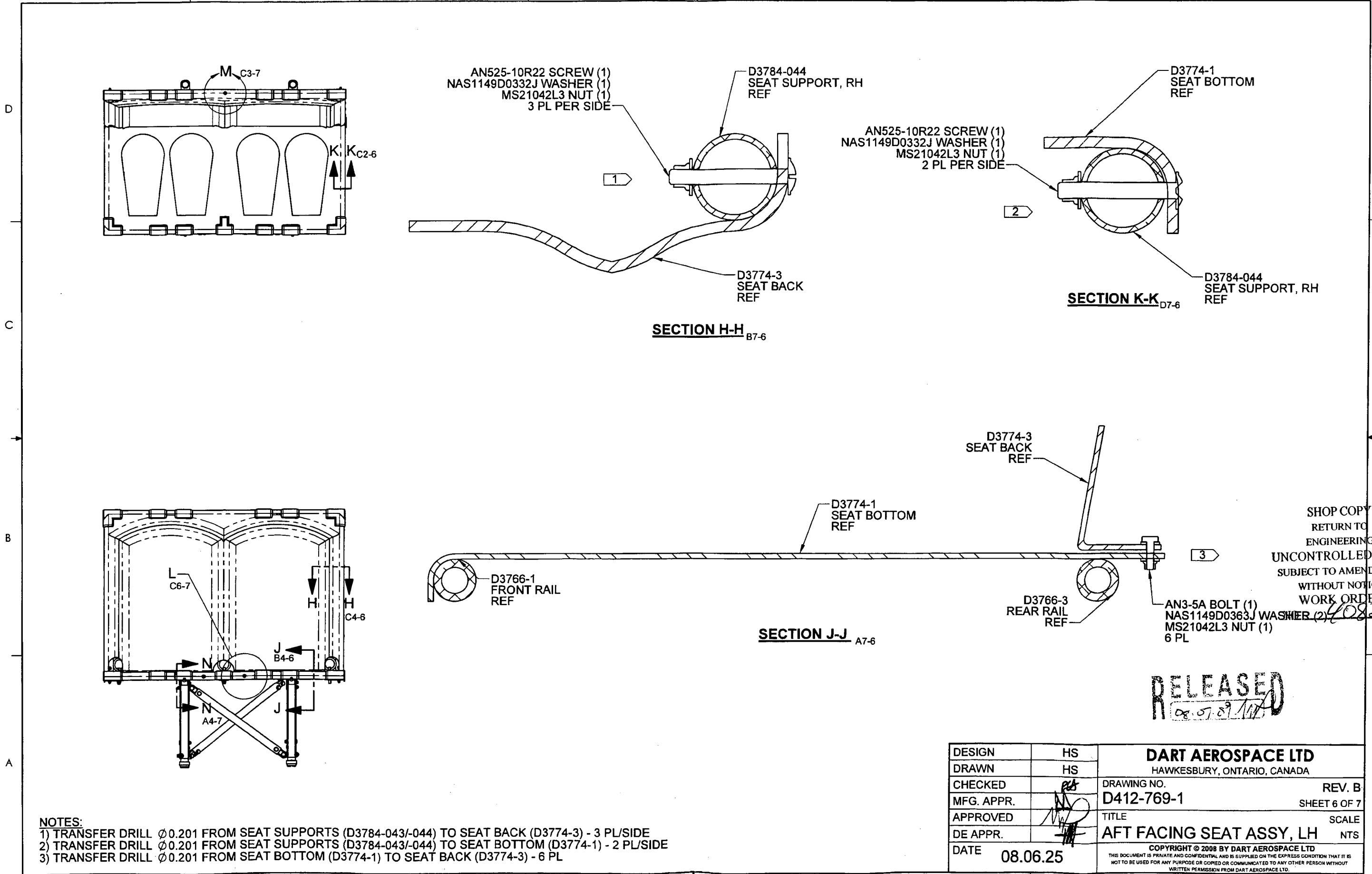
RELEASED
09-07-09

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>AS</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>AS</u>	D412-769-1	SHEET 5 OF 7
APPROVED	<u>AS</u>	TITLE	SCALE
DE APPR.	<u>AS</u>	AFT FACING SEAT ASSY, LH	
DATE	08.06.25	NTS	

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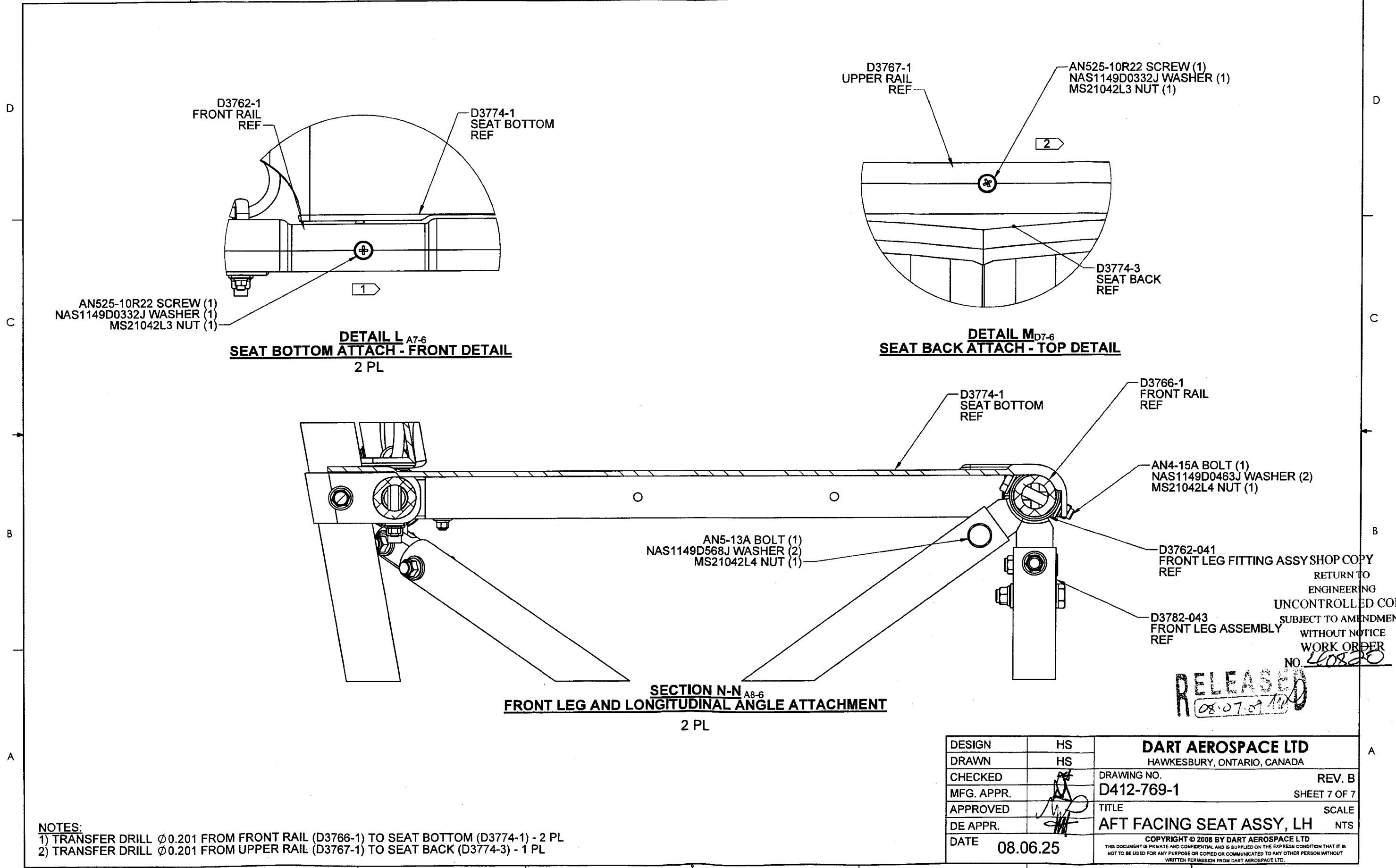
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